

5/20 Split

DART AEROSPACE LTD	Work Order:	229594
Description: Hi - Step Leg Assembly	Part Number:	D3065-041
Dwg: D3065 Rev. A1 A2 <i>RF 03-02-17 RF 03-02-28</i>	Qty:	60 48
		Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller <i>Dwg. not required RF 02.11.04</i> (Minimum lots of 30)	HA	05.04.13	60
2	MV	Cut blanks: 3.600" x 4.500" (grain along 4.500") <i>M17347</i> Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick <i>30204</i> (M2024T3S.040) Batch <i>M16548</i> Identify as D3065-1 <i>4.320" RF 02.11.29 4.320"</i>	BC	05/04/20	60 PTO
3	MV	Cut blanks: 6.600" x 4.250" (grain along 4.250" <i>4.320"</i>) <i>RF</i> Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick <i>02.11.29</i> (M2024T3S.040) Batch <i>M16548</i> Identify as D3065-3 <i>M17347</i>	BC	05/04/20	60
4	MV	Cut blanks: 4.580" x 4.500" (grain along 4.500") Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch <i>M17347</i> Identify as D3065-7	BC	05/04/20	60
5	MV	Cut blanks: 16.61" x 8.51" (grain along 8.51") for each leg. Material: 5052-H32 Sheet (QQ-A-250/8) 0.080" thick (M5052H32S.080) Batch <i>M15673</i> Identify as D3065-5 <i>M17124</i> (Note: make 2 legs per assembly)	BC	05/04/20	120
6	MV	Cut blanks: 16.490" x 0.750" for each spacer. (-0.00/+0.010) Material: 5052-H32 Sheet (QQ-A-250/8) 0.080" thick (M5052H32S.080) Batch <i>M17124</i> Identify as D3066-1 (Note: make 2 spacers per assembly)	BC	05/04/20	120
7	MV	Machine D3065-1 as per folio FA182 and Dwg D3065, use stack of 15.	SA	05.04.20	60
8	MV	Deburr to take measurement	SA	05.04.20	60
9	QC2	Inspect parts as they come off the CNC machine	SA	05.04.20	60
10	QC8	Second check	Er	05/04/20	60
11	MV	Machine D3065-3 as per folio FA180 and Dwg D3065, use stack of 15.	SA	05.04.20	60
12	MV	Deburr to take measurement	SA	05.04.20	60
13	QC2	Inspect parts as they come off the CNC machine	SA	05.04.20	60
14	QC8	Second check	Er	05/04/20	60
15	MV	Machine D3065-7 as per folio FA181 and Dwg D3065, use stack of 15.	SA	05.04.20	60
16	MV	Deburr to take measurement	SA	05.04.20	60
17	QC2	Inspect parts as they come off the CNC machine	SA	05.04.20	60
18	QC8	Second check	Er	05/04/20	60
19	MV	Machine D3065-5 as per folio FA179 and Dwg D3065, use stack of 10.	/	/	/

05.03.09 #4

RELEASED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 2295		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr.	Action Description Design Mgr	Sign & Date			
05-05-30	7	Noticed during Step 28. D3065-1 stock is not machined on one side .005" over tolerance of 0.010". 8 scrap because they're bent over tolerance.	<i>[Signature]</i>	Grind .005" off edge of remaining 7 D3065-1.	SB 05/05/30	<i>[Signature]</i> 05-05-30	<i>[Signature]</i>	<i>[Signature]</i> 05-05-30
05/05/31	28	D 3065-1 4 scrap D 3065-7 1 scrap D 3065-3 1 scrap Bend were bent over tolerance	<i>[Signature]</i>	Scrap destroy	SB 05/05/31	<i>[Signature]</i> 05-05-31	<i>[Signature]</i>	<i>[Signature]</i> 05-05-31
05/06/07	31	11 3065-7 5.78 26 D3065-3 6.01 20 D3065-5 5.31	<i>[Signature]</i>	Identify & Stock	SB 05/06/07	<i>[Signature]</i> 05-06-07	<i>[Signature]</i>	<i>[Signature]</i> 05-06-07

Part No: D3065-041

PAR #:

Fault Category: Prod/Machined

NCR: Yes No

DQA: *[Signature]*

Date: 05/07/05

NOTE: Date & initial all entries

QA: N/C Closed: *[Signature]*

Date: 05.07.05

DART AEROSPACE LTD		Work Order:	22959
Description: Hi - Step Leg Assembly		Part Number:	D3065-041
RF 03.02.28			
Dwg: D3065 Rev. A2		Qty:	
RF 03.02.17			Page 2 of 2

Step	Location	Procedure	By	Date	Qty																								
19	MV	Machine D3065-5 as per folio FA179 and Dwg D3065, use stack of 10.	En	05/04/22	120																								
20	MV	Deburr to take measurement	En	05/04/22	120																								
21	QC2	Inspect parts as they come off the CNC machine	En	05/04/22	120																								
22	QC8	Second check	En	05/04/22	120																								
23	MV	Machine D3066-1 as per Folio FA280 and Dwg D3066, use stack of 10.	En	05/04/22	120																								
24	MV	Deburr to take measurement	En	05/04/22	120																								
25	QC2	Inspect parts as they come off the CNC machine	En	05/04/22	120																								
26	QC8	Second check	En	05/04/22	120																								
27	GA	Deburr D3065-1, D3065-3, D3065-5, D3065-7 & D3066-1 stack. 3930 50 67 43 67	FF	05/05/26	X																								
28	GB	Bend D3065-1, D3065-3 & D3065-7 as per Dwg D3065 48 74 59	SB	05/06/01	48																								
29	QC5	Inspect work to Step 28	2	05-06-01	48																								
30	FP	Chemical conversion coat as per QSI 005 4.1 RF 02.11.06 D3065-1, D3065-3, D3065-5, D3065-7 & D3066-1	FF	05-06-01	48																								
31	GA	Assemble as per Dwg D3065 and identify as D3065-041 Assembly. <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3065-1</td><td>Spacer</td><td>B 22959</td></tr><tr><td>1</td><td>D3065-3</td><td>Spacer</td><td>B 22959</td></tr><tr><td>2</td><td>D3065-5</td><td>Leg</td><td>B 22959</td></tr><tr><td>1</td><td>D3065-7</td><td>Spacer</td><td>B 22959</td></tr><tr><td>30</td><td>MS20470AD4-4</td><td>Rivet</td><td>M 15829</td></tr></table>	Qty	Part Number	Description	Batch	1	D3065-1	Spacer	B 22959	1	D3065-3	Spacer	B 22959	2	D3065-5	Leg	B 22959	1	D3065-7	Spacer	B 22959	30	MS20470AD4-4	Rivet	M 15829	SB	05/06/07	48
Qty	Part Number	Description	Batch																										
1	D3065-1	Spacer	B 22959																										
1	D3065-3	Spacer	B 22959																										
2	D3065-5	Leg	B 22959																										
1	D3065-7	Spacer	B 22959																										
30	MS20470AD4-4	Rivet	M 15829																										
32	QC5	Inspect work to Step 31	2	05-06-03	48																								
33	GA	Identify and Stock D3065-041 Hi-Step Leg Assembly D3066-1 Spacer 5.19	PD	05-06-20	48																								
34	AC	Cost / part 34.35	SB	05/06/07	120																								
35	DC	Close W/O 35.05 Inspect Level 21	548	05.07.04	120																								
			dy	05/07/05	48																								

Rev	Date	Change	Revised By	Approved
A	01.12.10	New Issue	SM	
B	02.09.10	Re-format; Incorporated D3065-1/-3/-5/-7	KJ	
C	02.11.01	Incorporated D3066-1 IPP	KJ RF	

RELEASED
02/11/04 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05-05-30	19	4x D3065-5 no good. Vertical dimension under tolerance. Rivet holes to close					

NCR: 2259		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/04/20	# 11	one stack (15) SCRAP D3065-3 Drill Broke	<i>[Signature]</i> per 05-05-17	Destroy & Replace STACK of 15	SD 05.05.17	<i>[Signature]</i> 05.05.21	<i>[Signature]</i> per 05-05-21	<i>[Signature]</i> 05.05.21
05-05-20	27	Found in Basket Some pieces without Holes	<i>[Signature]</i> per 05-05-20	Destroy 16 x D 3065-7 12 x D 3065-1 CNC Re-do the holes	ml 05-05-20	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i> 05-05-30
05-05-30	19	4x D3065-5 no good. Vertical dimension under toler- ance: rivet holes to close to the edge. blanks cut too Short	<i>[Signature]</i> per 05-05-30	SCRAP & destroy	<i>[Signature]</i> 05-05-30	<i>[Signature]</i> 05-05-30	<i>[Signature]</i> per 05-05-30	<i>[Signature]</i> 05-05-30

Part No: D3065-041




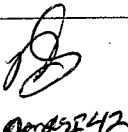

PAR #: _____

Fault Category: Prod/machinedNCR: (Yes) NoDQA: (Yes)Date: 05/07/16

NOTE: Date & initial all entries

QA: N/C Closed: (Yes)Date: 05.07.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 22959		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-06-13	32	Deep scratch in Material for D3065-5 leg	 pore 242	replace with 1/4" left over D3065-5 part & re-pivet leg Assembly	 05/06/13	 05-06-13	 pore 242	 05-06-13

Part No: D3065-041 PAR #: _____ Fault Category: Production / PAB. nss' med & small NCR: Yes No DQA: SD Date: 05/07/05

NOTE: Date & initial all entries QA: N/C Closed: 4 Date: 05.07.05

D3065-5DART AEROSPACE LTD		Work Order:	22959
Description: Step-Leg		Part Number:	D3065-5
Inspection Dwg: D3065	Rev: A2	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.458	+/-0.010	16.458	✓			
15.750	+/-0.005	15.748	✓			
2.250	+/-0.005	2.248	✓			
3.460	+/-0.005	3.457	✓			
0.865	+/-0.005	0.862	✓			
6.020	+/-0.005	6.015	✓			
1.205	+/-0.005	1.203	✓			
3.484	+/-0.005	3.481	✓			
0.871	+/-0.005	0.871	✓			
8.325	+/-0.010	8.325	✓			
0.551	+/-0.010	0.552	✓			
0.213	+0.005/-0.000	0.215	✓			
Ø0.128	+0.005/-0.000	0.130	✓			

Measured by: <i>Er</i>	Audited by: <i>ML</i>	Prototype Approval:	N/A
Date: 05/04/21	Date: 05/04/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	04.06.15	Added Ø0.128 dimension	KJ/JLM	<i>[Signature]</i>

RELEASED

04-06-17

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 11, 2005
07:31 am

Work Order No : 0022959
Project Name : D3065-041
Project For : WK520
Work Order Type : Main
Main WO Number :
House Part Number : D3065-041
Description : Step Leg Assembly
Manufactured : Yes
Amount Req'd : 60
Amount Done : 0
Start Date : 04-08-05
Est Finish Date : 05-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00